



Dart Aerospace Ltd.
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D3913-041
Job Sheet 175138



Part No: D3913-041

Job Qty: 1 ea

Part Name: Long Basket Base Assembly, 350



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/27/18

Job Tracking No:

Due Date: 4/27/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG D4020 REV A SHEET 4, D3913 REV D SHEETS 1,2,3,4,5 IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B chg qty's DD 10.04.12 verified by:EC IPP REV:C 12.07.24 AS PER DWG REV.B DD VERF:EC IPP REV:D 13.08.21 DWG REV.C / ECN 13-624 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		4/26/18	0.00	0.00	Start Up Large Fab-5		DM 18-4-17
100	Large Fab	1 pcs		4/26/18	0.00	10.00	Large Fab 1		CPC
110	QC	1 pcs		4/26/18	0.00	0.00	QC9		CPC
120	QC	1 pcs		4/26/18	0.00	0.00	QC5		CPC
125	HandFinish	1 pcs		4/26/18	0.00	0.29	HandFinish2		BE 18-4-26
130	Powdercoat	1 pcs		4/26/18	0.00	0.93	Powdercoat2		BE 18-4-27
135	Packaging	1 pcs		4/26/18	0.00	0.00	Packaging1		BE 18-4-27
140	QC	1 pcs		4/26/18	0.00	0.00	QC3		BE 18-4-27
150	HandFinish	1 pcs		4/27/18	0.00	0.50	HandFinish4		BE 18-4-27
160	QC	1 pcs		4/27/18	0.00	0.00	QC5		BE 18-4-27
170	Packaging	1 pcs		4/27/18	0.00	0.00	Packaging3-2		BE 18-4-27
180	QC21-SA	1 Ea		4/27/18	0.00	0.00	QC21		BE 18-4-27

Part Op 100 - 1- assemble ribs , weld as per dwg D3913 using DT9610A ***inspect before welding mesh*** 2-Cut D4020-1 base
Descriptions: mesh and tack weld all mesh on basket as per dwg D3913 and trim mesh to fit if necessary and trim to clear fasteners
holes on the ends 3- weld hinge (3) and Mounting brackets as per dwg D3913 ***take lid to locate hinge and bracket*** 4-
Weld D4672-1 blanking plates as per dwg
130 - 1- Plug holes and mask only interior of hinge (3) prior to powder coat
150 - Pick Kit

M138760 START: 8:40 CUT: 375° FINISH: 8:55

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 Ea (2 ea)	90-Start up Operation	5042562
D3913-1	Rib	1 Ea (1 ea)	90-Start up Operation	5049419
D3913-15	Wide Handle Plate	1 Ea (1 ea)	90-Start up Operation	5043834
D3913-3	Rib	1 Ea (1 ea)	90-Start up Operation	5054823
D3913-7	Rib	2 Ea (2 ea)	90-Start up Operation	5054996
D3913-9	Hinge Rib	1 Ea (1 ea)	90-Start up Operation	5053542
D3916-041	Rib Assembly	2 Ea (2 ea)	90-Start up Operation	
D3916-5	Light Rib	3 Ea (3 ea)	90-Start up Operation	5057665
D4016-1	Hinge Half, Base	3 Ea (3 ea)	90-Start up Operation	
D4017-7	Rib	3 Ea (3 ea)	90-Start up Operation	5045854
D4017-9	Rib	2 Ea (2 ea)	90-Start up Operation	5057458
D4020-11	End Mesh, Basket	2 Ea (2 ea)	90-Start up Operation	5049913
D4021-1	Handle Plate	3 Ea (3 ea)	90-Start up Operation	5057123
D4034-041	Aft Upper Rib Assembly	1 Ea (1 ea)	90-Start up Operation	5054125
D4034-043	Fwd Upper Rib Assembly	1 Ea (1 ea)	90-Start up Operation	5057479
D4672-1	Blanking Plate	2 Ea (2 ea)	90-Start up Operation	5054936
M304EX0.75-16F	Expanded Metal Flat SS	33 sf (33 ea)	90-Start up Operation	5049218
AN3-10A	Bolt	6 Ea (6 ea)	150-HandFinish	5041177
D2931	Bumper	2 Ea (2 ea)	150-HandFinish	F86435
MS20600-AD4W3	Cherry Rivet	2 Ea (2 ea)	150-HandFinish	5042091
MS21042L3	Nut	6 Ea (6 ea)	150-HandFinish	5038764
NAS1149F0332P	Washer 505752	12 Ea (12 ea)	150-HandFinish	5059025
D4021-5	Blanking Plate	2 Ea (2 ea)	150-HandFinish	

Job Allocations

002868

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2581	2	84	0
	D3913-1	1	12	0
	D3913-15	1	13	0
	D3913-3	1	14	0
	D3913-7	2	29	0
	D3913-9	1	8	0
	D3916-041	2	10	0
	D3916-5	3	18	0
	D4016-1	3	13	0
	D4017-7	3	42	0
	D4017-9	2	10	0
	D4020-11	2	20	0
	D4021-1	3	13	0
	D4034-041	1	8	0
	D4034-043	1	8	0
	D4672-1	2	64	0
	M304EX0.75-16F	33	788	0
	AN3-10A	6	234	0
	D2931	2	1,102	0
150-HandFinish	D4021-5	2	19	0
	MS20600-AD4W3	2	207	0
	MS21042L3	6	2,829	0
	NAS1149F0332P	12	1,411	0

Part Specifications

Specifications could not be found.

Master Unit 002326



Job No 175138



Container No: S062066



Part: D3913 - 041

Job No: 175138

Serial No/Batch: S062066

**Revision:
Inspector:**

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Date: 04/17/18